

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004675**Date Inspected:** 20-Nov-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 830**OSM Departure Time:** 1700**Location:** Muroran, Japan**CWI Name:** Chung-Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and nondestructive testing of Saddles.

Fabrication Shop 4**T1-1 Base**

No work performed on this date.

T1-1 Casting

No work performed on this date.

T1-2 Base

No work performed on this date. Intertek Testing Services Quality Control (QC) inspector Mr. Chung-Fu Kuan reported that welding would continue once the casting was rotated to allow welding of the stem plates to end plate in the flat position.

T1-3 Base

The QA inspector observed the in process assembly layout and fit-up operation of the structural steel plates for the Tower Saddle Base T1-3. The center rib plates were aligned on the base plate and to the stem plate. The JSW fitter personnel Kiyotaka Koanagi performed the layout in accordance with approved drawings. The work was not completed on this date and appears to meet the minimum requirements of the welding procedure

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

specification and contract documents.

W2-E2 Base

No work performed on this date.

W2-W1 Casting

The QA inspector observed the Nikko Inspection Services QC/NDT technician Mr. Harumi Kohama perform straight beam ultrasonic testing of casting W2-W1 trough areas marked as level I in the JSW procedure specification number SJ-2878 revision 2. The casting was scanned utilizing a Krautkramer Branson USM-3S, serial number 30178-1595, calibrated to 4/27/2008 for the following scan. The ultrasonic examination of the trough surface in the area of the ribs and transition of the ribs to the main body of the casting on the stamp mark side. A distance amplitude curve was recorded on the testing unit using 2.4mm diameter flat bottom holes. The testing was performed in accordance with the JSW procedure specification number SJ-2878 revision 2. The testing was not completed on this date and the work appears to meet the minimum requirements of the contract specifications.

Foundry

W2-W3 Casting

Two JSW employees were observed grinding areas where excess riser material from the exterior surface of the casting W2-W3 was removed utilizing the Air-Carbon Arc method. The grinding was performed to smooth the surface of the casting. Work was not completed on this date and appears to meet the minimum requirements of the contract documents.

T1-2 Casting

No work performed on this date.

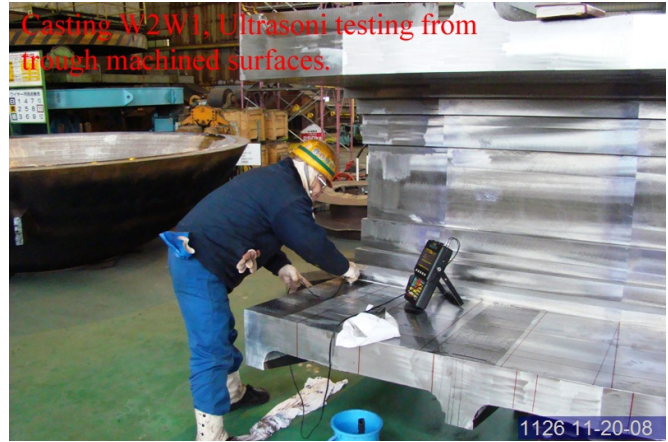
T1-3 Casting

Two JSW employees were observed removing excess riser material from the exterior surface of the casting T1-3. The material was removed utilizing the Air-Carbon Arc method. Work was not completed on this date and appears to meet the minimum requirements of the contract documents.

The following digital photographs illustrate observations of the activities being performed.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

There were general conversations with Intertek Testing Services Certified Welding Inspector Mr. Chung-Fu Kuan relative to the location of the welding and inspection personnel in the fabrication shop number 4.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

Inspected By:	Lanz,Joe	Quality Assurance Inspector
Reviewed By:	Brasel,Ron	QA Reviewer
